

Work Order ID 54764

December 21, 2009 9:06:17 AM



Page 1

Item ID: D2565-101

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2565 using DT 8313

SB 10/01/21

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Drill hole open to .316 Ø as per Dwg D2565 (one end only) ☐ Deburr and polish

⇒ m.d 10/01/26 6X

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8/06/27

(46)

Work Order ID 54764

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Item ID: D2565-101

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



11/13/10

10-01-27

X6

Ø

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm OVEN TEMPERATURE:

1:30pm FINISH TIME:

400°F

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7m 10/01/27 (6X)

150

Identify as per dwg & Stock Location 270

0.00



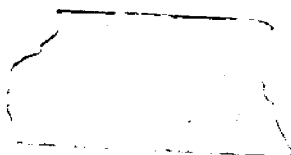
Packaging

Memo

0.00

Packaging

10-1-27 6X 5P



Work Order ID 54764

Page 3

December 21, 2009 9:06:20 AM

Item ID: D2565-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/28 JF

MF

10-1-27

Picklist Print

December 21, 2009 9:06:17 AM

Page 1

Work Order ID: 54764

Parent Item: D2565-101

Parent Item Name: Strut

Start Date: 12/21/09

Required Date: 1/04/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	326.9924	10.8000			



304 RD Tube .750 x .049W



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	326.9924	
107518	2.77	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
112652	85.89	
112800	208.6424	

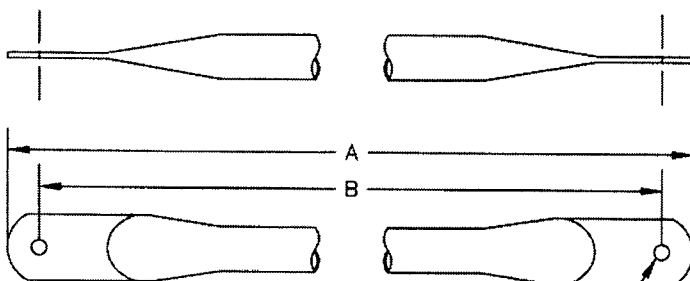
12 88 10/01/21 (2)



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

u10 54764



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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